Friday, 05/09/2008 10:09:45 AM

User:

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Type

Job Number : 41863 **Estimate Number** : 13052

Julie Lecocq

P.O. Number

This Issue

: 05/09/2008 : NC

First Issue : // : 41615

Previous Run

Prsht Rev.

Written By

Checked & Approved By

Comment

new issue 07-10-30 DD verified by: : Est Rev A

Ecn 1056 Rev A dwg DD Est Rev:B

: MACHINED PARTS

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

M6061T6T03125W058

Comment: Qty.:

Material:

Total:

(M6061T6T0.313W.058)

36.7500 f(s)

Batch: M109240

2.0 HARDINGE

Comment: 1-TURN AS PER FOLIO FA711& DWG D3670

FOLIO REV: A DWG REV:__

2-DEBURR AS REQUIRED

QC2 3.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

Comment: SECOND CHECK

5.0 PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Process Sheet

Drawing Name

Part Number

: D36704200 : D3670 REV A

Drawing Number Project Number

: N/A

Drawing Revision

Material

Due Date

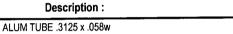
: 12/09/2008

: SPACER

Qty:

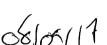
100 Um:

Each



SECOND CHECK

PACKAGING RESOURCE #1









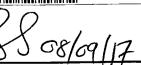
















Dart Aerospace Ltd

W/O:	<u> </u>		W	ORK ORDER CHANG	ES					
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									1 100 IIIgi	
			,							
Part No:		PAR #:	Fault Cat	egory:	_ NCR: Yes No DQA			A: Date:		
	R	esolution:	Dispositi	on:	_ QA: N	A: N/C Closed:			Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	ANCE ((NCR)				
DATE	STEP	Description of NC	Corrective Action Section			Veriti		cation Approval	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	,	Sign & Date	Section	on C	Chief Eng	QC Inspector
										ļ

NOTE: Date & initial all entries

Date:

Friday, 05/09/2008 10:09:45 AM

User: 🧓

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 41863

Part Number: D36704200

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U St. 09.18

Dart Aerospace Ltd

		WO	RK ORDER CHANG	GES	¥.				
STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·						
			•						
:	PAR #:	Fault Categ	jory:	NCI	CR: Yes No DQA: Date:				
Re	solution:	Disposition	ı:	QA:	N/C CI	osed:		Date: _	
	•	WORK ORDE	R NON-CONFORM	IANCE	(NCF	R)			
STED	Description of NC Section A					Verific	Verification	Approval	Approval
SIEP		Initial Chief Eng	Action Description Chief Eng		Sign 8 Date	Secti	Section C	Chief Eng	QC Inspector
		PAR #:	STEP PROCEDURE CHAN PAR #: Fault Category Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Section A Section Description	PAR #: Fault Category: NCF Resolution: Disposition: QA: WORK ORDER NON-CONFORMANCE STEP Description of NC Section A Corrective Action Section B Initial Action Description	STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C CI WORK ORDER NON-CONFORMANCE (NCF STEP Description of NC Section A	STEP PROCEDURE CHANGE By Date Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Section B Verific Section B S	STEP PROCEDURE CHANGE By Date Qty DESCRIPTION OF NO Section A Section C Sec	STEP PROCEDURE CHANGE By Date Qty Chief Eng./ Prod Mgr Description of NC Section A Description Section C Section C Chief Eng./ Prod Mgr NCR: Yes No DQA: Date: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section C Chief Eng./ Initial Action Description Sign & Section C Chief Eng./ Prod Mgr Approval Chief Eng./ Prod Mgr

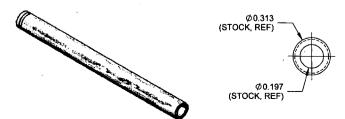
NOTE: Date & initial all entries

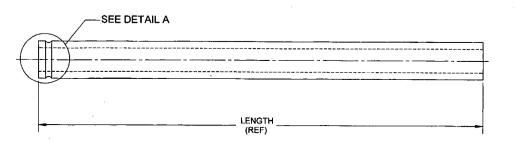
DART AEROSPACE LTD	Work Order:	41863
Description: Spacer	Part Number:	D3670-4200
Inspection Dwg: D3670 Rev: A		Page 1 of 1

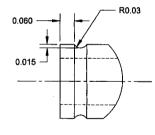
Inspection Dwg	: D3670 Re	v: A				Pag	ge 1 of 1
	FIRS	ST ARTICLE II	NSPECTI	ON CHE	CKLIST		
	_	X First Arti		_	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	nments
Ø0.313	+/-0.010	0,313					
Ø0.197	+/-0.010	0.197					
4.200	+/-0.010	4.196					
0.060	+/-0.010	-060					
R0.03	+/-0.030	7030					
0.015	+/-0.010	«C15					
		·					
	-						
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			,				
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					<u> </u>		
Measured by:	AZ	Audited by:	1		Prototype A	Approval:	N/A
Date:	08/07/16	Date: 08/04/17				N/A	
			/ / /		<u> </u>		
Rev Date Change Revis						evised by	Approve

		•		
Rev	Date	Change	Revised by	Approved
Α	08.01.16	New Issue	KJ/EC/DD	<u> </u>
			711	•

SPECIFICATION CONTROL DRAWING



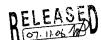




DETAIL A (SCALE 4:1)

SPECIFICATION: D3670, XXXX, SPACER LENGTH

WHERE XXXX IS LENGTH IN INCHES EG: 3.750" LONG SPACER: D3670-3750



NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS/MCBIES UNLESS OTHERWISE NOTED
2.5) BREAKSHARP EDGES: 0.005 TO 0.010 MAX
0 6) IDENTRIORION: NONE
TOWN OF THE COMMENT OF TH

Α	NEW IS	SUE	DC	07.10.19			
REV.			DESCRIPTION .	BY	DATE		
DESIGN DE			DART AEROSPACE LTD				
DRAWN	i	06	HAWKESBURY, ONTARIO, CANADA				
CHECKED		\perp_1	DRAWING NO.		REV. A		
MFG. APPR.		130	D3670		SHEET 1 OF 1		
APPROVED W		MI	TITLE		SCALE		
DE APPR.			SPACER 2				
DATE	07.1	0.19	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOGAMENT IS PRIVATE AND CONFIDENTIAL AND IS SEPTILED ON THE EXPRESS CONCINON THAT IT IS MUT TO BE USED FOR ANY PURPOSE ON COMED ON COMMUNICATION TO ANY PURPOSE ON WITHOUT WATTEN PERMISSION FROM DAIT APROSPACE LTD.				